Work Orde Tuesday, Februa											Page 1
Item ID: Revision ID:	D3248-1			Accept					Setup Sta	rt	
	Doubler								Sto	p q	
Start Date: Required Date: Reference:	2/22/2011 2/25/2011	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I Customer:	D:				1 188211991	
Approvals:	Process Plan	n:	Date:	DD Tooling:	Da		_	.]	Run Sta		
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	PP	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3248	Rev	A									
100 Waterjet		PURCHASING Memo		0.00				1311-	ə->4		
FLOW CNC Waterjo		1-Cut as per Dwg Rev: Prog Rev:	Dwg							(Ta	

110

QC2- Inspect parts off machine FAI/FAIB

2-Deburr if necessary

0.00

Memo

0.00

PG-6-118A

Quality Control

Dart Aerospace I	Ltd
------------------	-----

Duit Ac	oopacc	Liu						-
W/O:			٧	VORK ORDER CHANG	SES			
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,				<u>. </u>				
		·						
Part No: PAR #: _								
Resolution:			Disposit	tion:	QA: N/C C	losed:	Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	₹)		
DATE STEP		Description of NC Section A	Initial Action Descri		tion B		n Approval Chief Eng	Approval QC inspector
			Chief Eng	Chief Eng	Date			
				·				

Work Order ID 66555

Tuesday, February 22, 2011 9:20:27 AM



Page 2

Item ID:

D3248-1

Accept

Setup Start

Stop



Revision ID:

Doubler Item Name:

Required Date: 2/25/2011

2/22/2011

QC:

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00 8,1100/24 **Tool ID**

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

130

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

0.00

12 6 9/ 11/02/74

140

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

12 BR 11-2-24

Dart Aerospace L	∟ta
------------------	-----

W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										į		
Part No: PAR #:		PAR #:	Fault Cate	egory:	_ NCR	: Yes N	No DQA: Date:					
Resolution:			Disposition	on:	QA:	N/C Clo	sed:		Date:	·····		
NCR:			WORK ORE	DER NON-CONFORM	ANCE	(NCR)						
DATE	DATE OFFI DESCRIPTION OF NC			verification Approval Approva				Approvai				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
							 					
									1			

Work Order ID 66555

Tuesday, February 22, 2011 9:20:27 AM



Page 3

Item ID:

D3248-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Doubler

Required Date: 2/25/2011

QC:

2/22/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start Run

Stop



Sequence ID/

Work Center ID

150

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

nlo2/2499 mc 11-02-24

Dail Aciospace Lla	Dart	Aeros	pace	Ltd
--------------------	------	-------	------	-----

	•										
W/O:			WC	RK ORDER CHANGI	ES						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						ĺ					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	s No DQA: Date:					
	Re	solution:	Disposition	ı:	_ QA: N/C Clo	sed:		Date:			
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)						
		Description of NC	Description of NC Corrective Action			Verifica	ation	Approval	Approval		
DATE STE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector		
					i i		,				

Picklist Print

Tuesday, February 22, 2011 9:20:32 AM

Work Order ID: 66555

Parent Item: D3248-1

Parent Item Name: Doubler



Start Date: 2/22/2011

Required Date: 2/25/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP B 04.10.26 D3248-1 no longer made in-house.

11.02.07 now made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	142.3000	0.0937	1.183579	1		
										IB.	1-2-24		

5052-H32 .063 Sheet

Location	Loc Qty	Loc Code		
MAT	142.3			(10)
114322	142.3		114322	
11				•

r,

Dart Ae	rospace	Ltd							,		
W/O:			W	ORK ORDER CHANGE	S						
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:									
	Re	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _			
NCR:		· V	VORK ORD	ER NON-CONFORMAN	NCE (NCF	R)					
DATE	0.750	Description of NC	Corrective Action Section			Verifica		on Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	I	ion C	Chief Eng	QC Inspector		

DART AEROSPACE LTD	Work Order:	64555
Description: Doubler	Part Number:	D3248-1
Inspection Dwg: D3248 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	F	Prototype
---	---------------	---	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.50	+/-0.030	(50	太		26	
3.60	+/-0.030	3,547	>e		V 1302	
Ø0.257	+0.005/-0.000	, 761	بح		V	
Ø0.128	+0.005/-0.000	, 131	>		V	
0.38	+/-0.030	.380	>		V	
1.000	+/-0.010	1.000	75	<u> </u>	V	
3.75	+/-0.030	3,749	8		V	
0.38	+/-0.030	315	Ø		V	,
R0.38	+/-0.030	.39	7		R.G	
2.000	+/-0.010	5,063	7		V	
2.625	+/-0.010	7.638	>		V	
						-
		<u></u>				
		- 4				
		`	*			

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	56-6-11	Date: 11/10/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue	KJ/JLM A	
			- '(1	/ /

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
Resolution:		Disposition: 0			QA: N/C Closed: Dat				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A		on B	Verifi	cation	Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng		Sign & Section C	tion C	Chief Eng	QC Inspector
								÷	
					ļ				
1	1								





DESIGN	DRAWN BY		ROSPACE LTD Y, ONTARIO, CANADA	
CHECKED	APPROVED -	drawing no. D3248	SHEET	REV. A 1 OF 1
DATE		TITLE		SCALE
04.04.06		DOUBLER		1:1

04.04.06 | NEW ISSUE SHOP COPY **RETURN TO ENGINEERING** R0.50 SUBJECT TO AMENDMENT WITHOUT NOTICE **UNCONTROLLED COPY** Ø0.257 ·128 O Ø0.128 (TYP) .064 3.60 2.625 2.000 3 M 1_000 1.36 1316 3/6 (2 PLS) 0.38 0.38 -0.500 .316 1.000 .872 - 1.500 3.75

D3248-1

NOTE:

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.063 THICK (REF. DART SPEC. M5052H32S.063)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
 3) FINISH: CHEMICAL CONVERION COAT PER DART QSI 005 4.1
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) PART IS SYMMETRIC ABOUT CENTERLINE

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

									<u> </u>	
W/O:			V	ORK ORDER CHANG	GES				`	
DATE STEP		PRO	PROCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										,
Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQ	\ :		
			Disposition:						•	
NCR:		\	WORK OR	DER NON-CONFORM	IANCE (NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Secondarial Action Description		n B Sign &		ation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Jecu		· Office Eng	Qo mopooto.
										